

5/32

(1)

DART AEROSPACE LTD	Work Order:	23351
Description: Plate	Part Number:	D3219-1
Dwg: D3219 Rev. A	Qty:	100
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 4	TH	05.05.20	100
2	MV	(1) blank makes (2) D3219-1 Cut blanks: 4.350" x 3.200" Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Identify for D3219-1 Batch: <u>M17685</u>	En	05.06.22	100
3	MV	Machine as per Folio FA403 and Dwg D3219 Stack of 4 Identify as D3219-1	BL	05.06.22	100
4	QC2	Inspect parts as they come off the CNC machine	BL	05.06.23	100
5	QC8	Second check	EL	05.06.23	100
6	GA	Deburr	FF	05.06.28	100
7	QC6	Inspect work to Step 6	2	05.07.06	100
8	ST	Identify and Stock	2	05.07.06	100
9	AC	Cost / part <u>3.397</u>	AL	05/07/06	100
10	DC	Close W/O <u>3.02</u> Inspect Level 21	TH	05/07/07	100

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	<i>[Signature]</i> 05/04/22

RELEASED
05/04/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-07-06	6	during deburring if any marks are found on material they should be removed, according to QSI tolerances. may be add to step 6, <i>Permanent change</i>	<i>[Signature]</i>	05-07-14	N/A	<i>[Signature]</i>	<i>[Signature]</i> 05-07-06

NCR: 23351		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/22	#3	4 (four) parts scrap use wrong Drill	<i>[Signature]</i>	Destroy + Replace	<i>[Signature]</i> 05.06.22	<i>[Signature]</i> 05.06.23	<i>[Signature]</i> 05.06.23	<i>[Signature]</i> 05.06.23

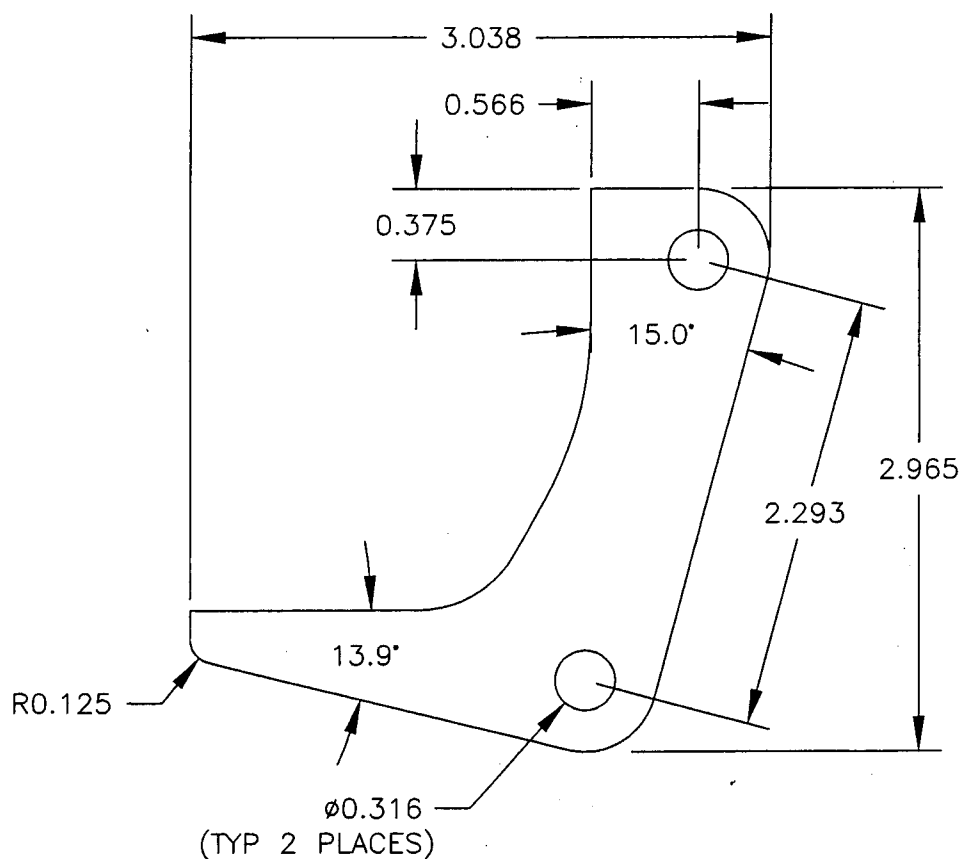
Part No: D3219-1 PAR #: _____ Fault Category: Prod/machine parts NCR: Yes No DQA: [Signature] Date: 05/07/07

NOTE: Date & initial all entries QA: N/C Closed: [Signature] Date: 05.07.07



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05 *#*



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPR1"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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SUD. F. T. ELEMENT
VERIFICATION
WORK ORDER
NO. 23351

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023351
Project Name : D3219-1
Project For : WK532
Work Order Type : Main
Main WO Number :
House Part Number : D3219-1
Description : Support
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00